

Work Order ID 50781

July 22, 2009 12:46:46 PM

24/7/09

Page 1

Item ID: D3889-041

Accept

Setup Start

Revision ID: A

Stop

Item Name: Panel, Floor

Start Date: 07/22/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *09-07-22*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3889

A

4

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3889-1

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B 9-7-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-7-23

(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Start Date: 07/22/2009 Start Qty: 4.00

Required Date: 07/24/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *09-08-22* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

2> 509/07/24

(24)

d

-

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

m...d 09/07/24

(4x)

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

140

Packaging

0.00

Packaging

Memo

0.00

Packaging

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Page 3

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Setup Start

Revision ID: A

Stop

Item Name: Panel, Floor

Start Date: 07/22/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: M108891

m-h 09/07/24 (4X)

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

=> 502/07/24

(4X) 4

170

0.00



Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Packaging

09/12/24

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Work Order ID 50781

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Page 4

Item ID: D3889-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Panel, Floor

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/27

CMF 09-07-24

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

July 22, 2009 12:46:45 PM

Page 1

Work Order ID: 50781

Parent Item: D3889-041RevA

Parent Item Name: Panel, Floor

Comments:

Start Date: 07/22/2009

Required Date: 07/24/2009

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MLEXS.125-F60029-04 | | Purchased | No | | | 100 | sf | 709.8406 | 34.4947 | | | |



GE PLASTICS LEXAN SHEET

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 709.8406316 | |
| 103106 | 7.8 | |
| 105330 | 54 | |
| 109455 | 0.03 | |
| 111710 | 648.010632 | |

D3889-3RevA

Manufactured No

140 Each

0.0000

4.0000



Gasket



111710 B 9-7-23

50791

ME 09-07-23

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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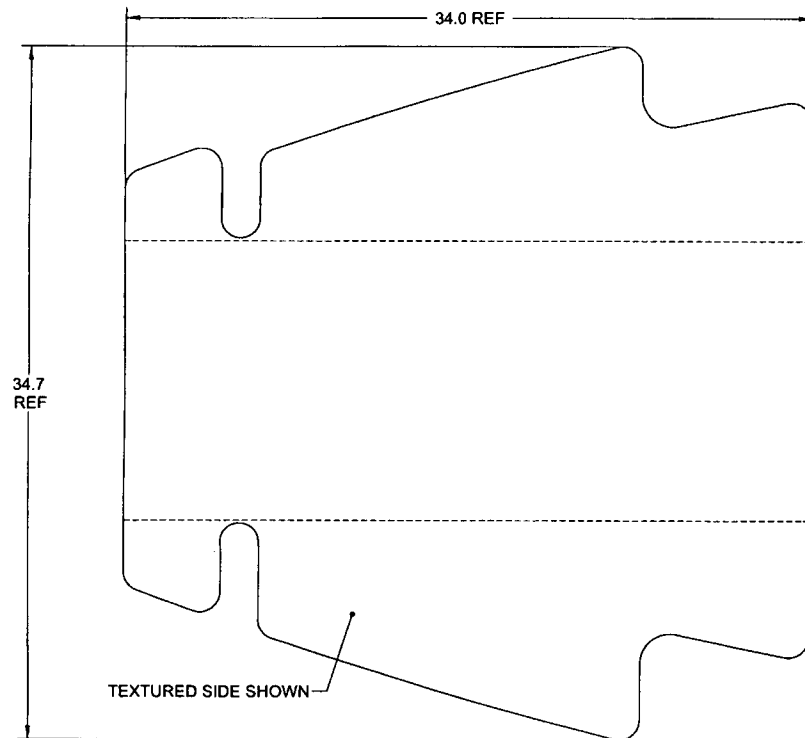
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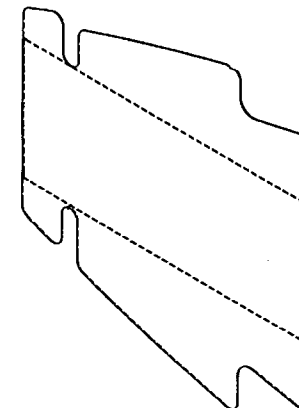
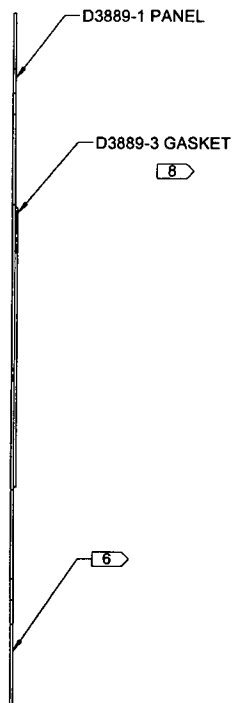
PARTS LIST

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|--------------|
| 1 | X | D3889-041 | PANEL, FLOOR |
| 2 | 1 | D3889-1 | PANEL |
| 3 | 1 | D3889-3 | GASKET |
| 4 | A/R | 3M 1300 | ADHESIVE |

**D3889-041 PANEL, FLOOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



#50781
WLF
09-07-22

RELEASED
9/6/16 WLF

| A | | NEW ISSUE | | CP | 09.04.20 |
|------------|----------|--|--|--|----------|
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | | | | | |
| CHECKED | | DRAWING NO. D3889 | | REV. A | |
| MFG. APPR. | | TITLE PANEL, FLOOR | | SHEET 1 OF 3 | |
| APPROVED | | | | SCALE | |
| DE APPR. | | | | NTS | |
| DATE | 09.04.20 | COPYRIGHT © 2009 BY DART AEROSPACE LTD | | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

Dart Aerospace Ltd

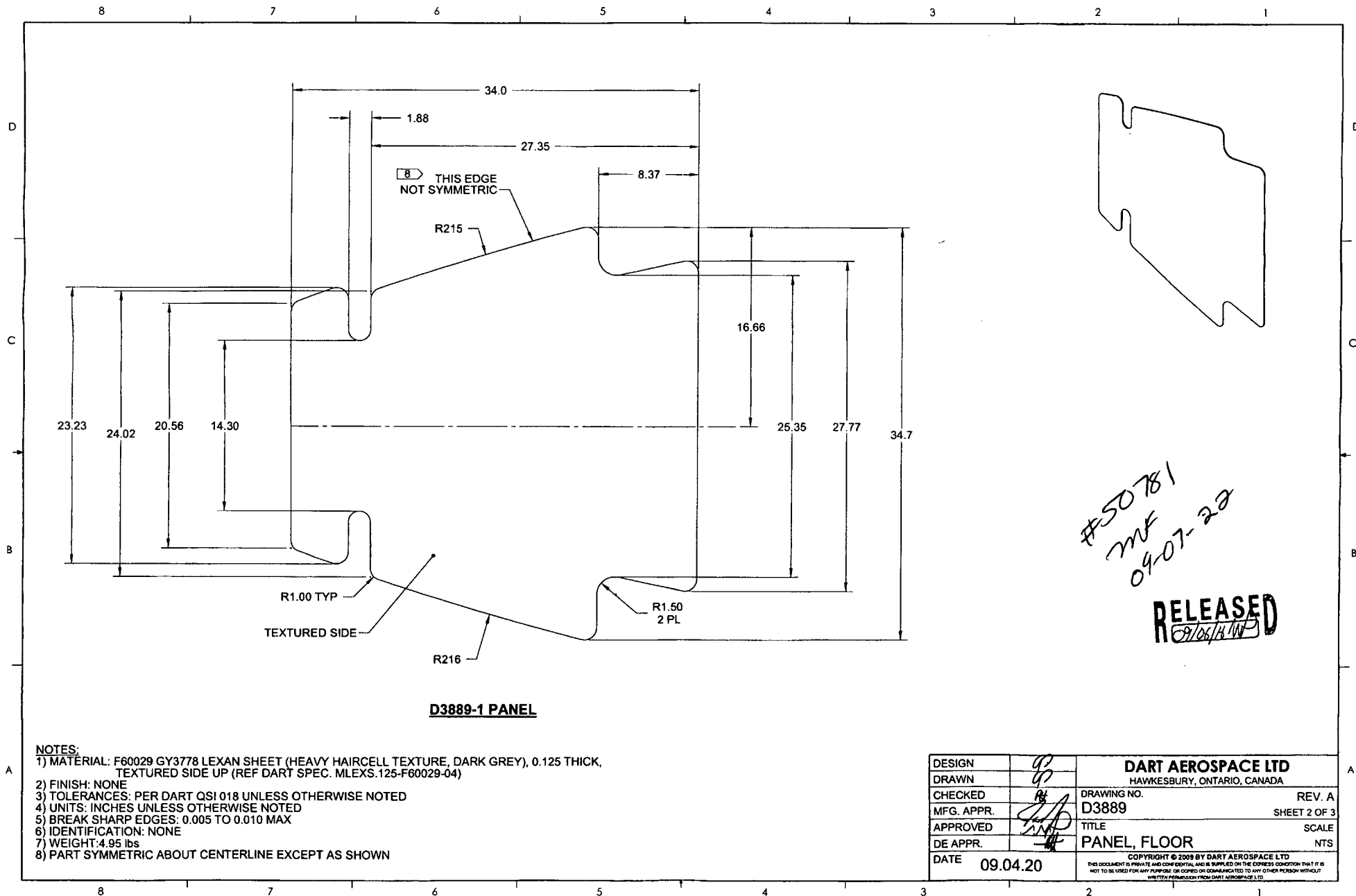
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Dart Aerospace Ltd

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